

Work Order ID 86060

86060

Page 1

Item ID: D4125-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Sump

Start Date: 20/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4125

C

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Cut Blank at 13.375"

81 12-06-24 (x4)

105

0.00

105

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machined as per folio FB078

Rev: AA

Dwg: C

Deburr

B.A 12/06/26

4 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									

B-A 12/06/26

4

φ

JL 12-02-28

4

4 76 12-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 20/06/2012 **Start Qty:** 4.00

4

Customer:

Required Date: 04/07/2012 Req'd Qty: 4.00

4

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 QC3- Inspect Part Finish

0.00

140

QC Memo

0.00

Quality Control

12-07-03

150	Identify as per dwg & Stock	Location: <u>WA</u>	0.00
-----	-----------------------------	---------------------	------

150

Packaging	Memo
-----------	------

0.00

Packaging

Ae
12.07.03

160	QC21- Final Inspection - Work Order Release	0.00
-----	---	------

160

QC Memo

0.00

Quality Control

ME
12-07-03

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

June-20-12 12:51:21 PM

Page 1

Work Order ID: 86060

86060

Parent Item: D4125-1

D4125-1

Parent Item Name: Sump

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.07.21 new issue DD verf:EC

IPP Rev:B 11/12/05 as per dwg. rev.B JFS verf:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X08.00 0		Purchased		No		100	f	16.8544	1.115	4.694737			

M6061T6B2 000X08 000

6061-T6 BAR 2.00' X 8.00"

**

12-06-24

Location

MAT005

119805

121626

Loc Qty

16.8544

4.8544

12

Loc Code

4.8544

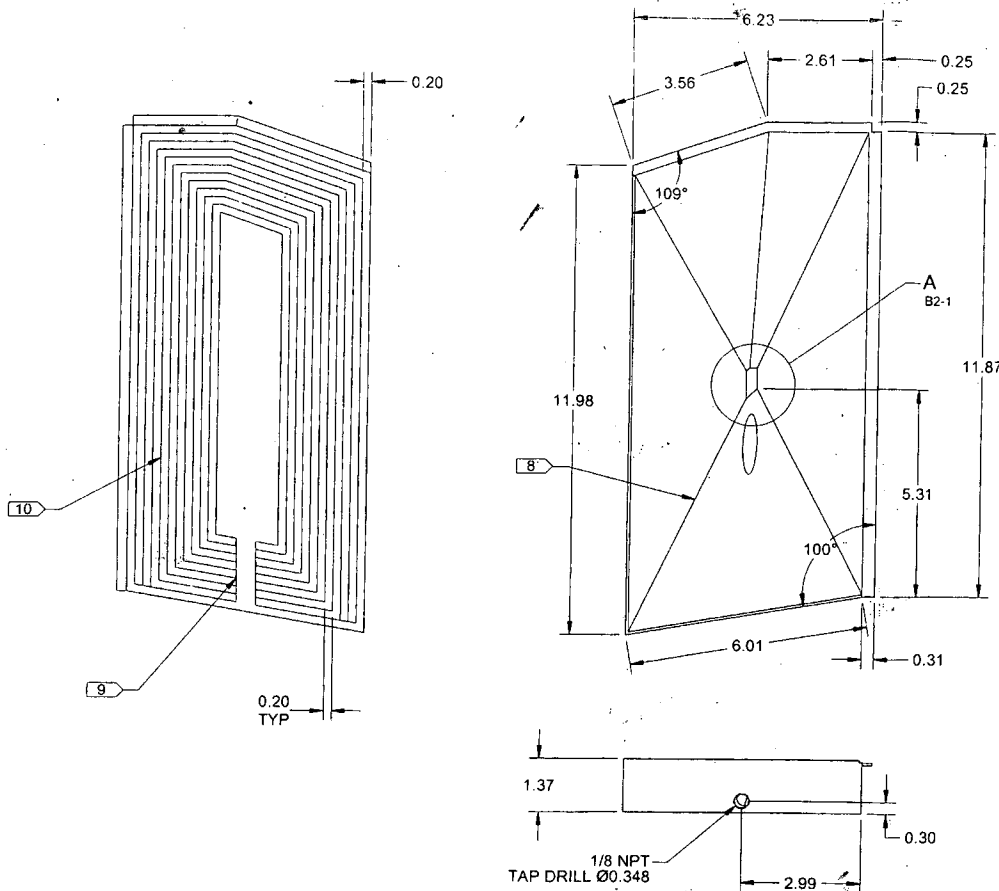
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 810060 MLJ
12/06/20

DETAIL A
SCALE 3X
C5-1

RELEASED
2012-03-02
MLJ

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B1.750X6.250
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.26 lbs
 - 8) MAXIMUM INSIDE RADIUS = 0.250
 - 9) MINIMUM RADIUS = 0.187
 - 10) MINIMUM RADIUS = 0.015

D4125-1 FWD SEDIMENT BOWL

C	MODIFY DESIGN OF -1/-3: ADD PERIMETER WALL, CREATE EQUAL STEPS.	DC	11.11.29
B	MODIFY DESIGN OF -1/-3, REMOVED -041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.11.29		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4125	REV. C SHEET 1 OF 2
TITLE SEDIMENT BOWLS	SCALE NTS
COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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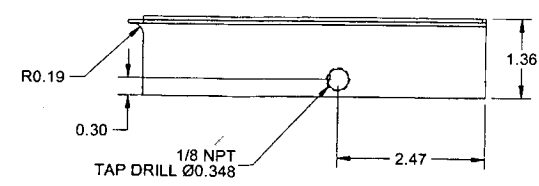
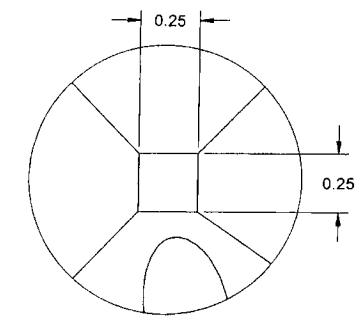
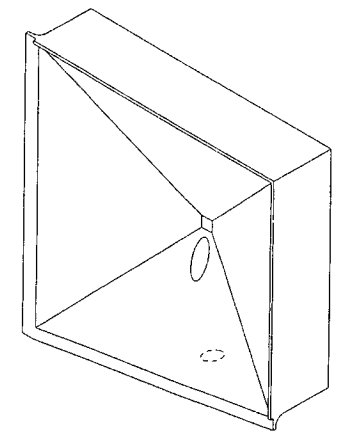
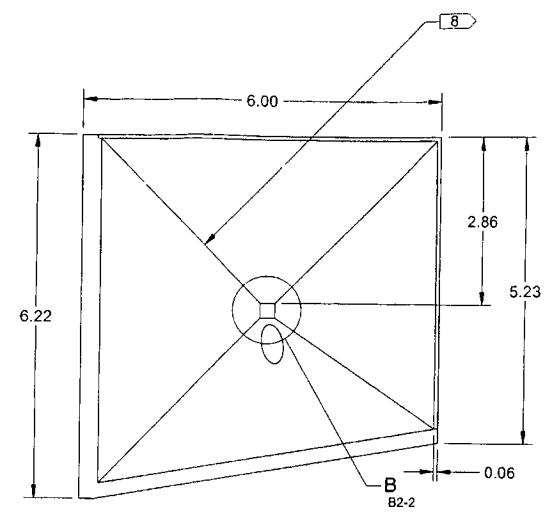
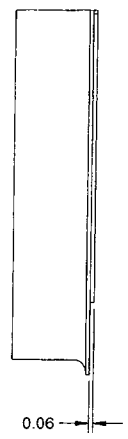
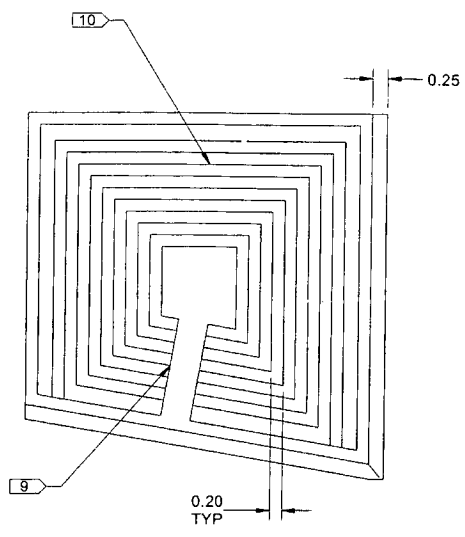
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NOTE: Date & initial all entries

06060



DETAIL B
SCALE 4X
C4-2

RELEASED
2012-03-02

D4125-3 AFT SEDIMENT BOWL

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B1.750X6.000
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.16 lbs
 - 8) MAXIMUM INSIDE RADIUS = 0.250
 - 9) MINIMUM RADIUS = 0.187
 - 10) MINIMUM RADIUS = 0.015

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO. D4125	REV. C
MFG. APPR.	<i>BC</i>	SHEET 2 OF 2	
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	SEDIMENT BOWLS	NTS
DATE	11.11.29	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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DART AEROSPACE LTD	Work Order: 86060
Description: SEDIMENT BOWL	Part Number: D4125-1
Inspection Dwg: D4125 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.20	+/- .030	0.200	✓		Vern	GA-01
11.98	+/- .030	11.980	✓		Vern	CNC-02
3.56	+/- .030	3.590	✓			
6.23	+/- .030	6.234	✓			
2.61	+/- .030	2.580	✓			
.25	+/- .030	0.250	✓			
.25	+/- .030	0.250	✓			
11.87	+/- .030	11.872	✓			
6.01	+/- .030	6.040	✓			
.31	+/- .030	0.310	✓			
1.37	+/- .030	1.373	✓			
.30	+/- .030	0.300	✓			
2.99	+/- .030	2.987	✓			

Measured by: J.A.	Audited by: SL	Preliminary Approval:
Date: 12/06/27	Date: 12-02-28	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

